Work Order October-17-11 10				*750)52*						Page 1
Revision ID: Item Name: V Start Date: 1 Required Date: 2	D3290-3 Window 7/10/2011 27/10/2011	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	Accept	*N900 Cust Item I Customer:		100)* s	etup Star Stop	IA	S1* S2*
		in: <u>M.L.</u> J	Date: 11 0 1 5			ate:		R	Run Star Stop		R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									- Stamp
D3290	Rev	С									
*100 *100* Waterjet FLOW CNC Waterjet		FLOW WATER JET Memo 1-Cut as pe Deburr if no	r Dwg D3290 Dwg Rev:_ ecessary	0.00 0.00 Prog Rev:	2-			<u>B</u> 11-	-[-1	(14	2)
110 *110* QC Quality Control		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				Bu	<u>+11-1</u>		
					****			۸			
*120 *120*		QC8- Inspect parts - sec	cond check	0.00					n 1)) (000
QC Quality Control		Memo		0.00							

Dart	Aerospace	Ltd
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Dart Aer	rospace Ltd	d								<u> </u>
N/O:			CW	RK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
	Resc	olution:							Date: _	
NCR:			WORK ORDE	R NON-CONFOR	MANCE	(NCR	()		•	
		Description of NC			Section B	01 0		ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descriptio	n	Sign & Date	Sec	tion C	Chief Eng	QC Inspecto

Work Order ID 75052 *75052* Page 2 October-17-11 10:39:17 AM Item ID: D3290-3 Accept *N900040100* Setup Start **Revision ID:** Window Item Name: **Start Date:** 17/10/2011 **Start Otv: 12.00 Cust Item ID: Required Date: 27/10/2011** Req'd Qty: 12.00 **Customer:** Reference: Start Run Process Plan: **Approvals:** Date: **Tooling:** Date: Date:____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID Description Qty Stamp **Run Hours** Code Qty Number 130 0.00 HAND FINISHING THERMOFORMING *130* Thermoform 0.00 Memo Thermoforming Machine Without removing protective skinremove sharp edge by degurring. 140 0.00 THERMOFORMING MACHINE *140* x 14 Thermoform 0.00 Memo 1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg. Thermoforming Machine Folio Rev_____ 2-Engrave part# & batch#. (D3290-3) 150 QC2- Inspect parts off machine FAI/FAIB 0.00 *150* x14 QC 0.00 Memo

Quality Control

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DG	A:	Date:	
	R	esolution:	Disposition	ı:	QA: N/C	Closed:	-	Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
		Description of NC			ion B	Verif	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	ok Sec	tion C	Chief Eng.	QC Inspector

Work Order ID 75052 *75052* Page 3 October-17-11 10:39:17 AM Item ID: D3290-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Window **Start Date:** 17/10/2011 **Start Qty: 12.00 Cust Item ID:** Req'd Qty: 12.00 **Required Date: 27/10/2011 Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Stamp Oty Otv Number 170 0.00 HAND FINISHING THERMOFORMING *170* Thermoform 0.00 Memo Thermoforming Machine Water sand and buff to remove scractches if required 180 QC5- Inspect part completeness to step on W/O 0.00 *120* QC 0.00 Memo Quality Control

190

100

Packaging

Identify as per dwg & Stock Location: Lecucity

Room.

Memo

0.00

×14

0.00

Packaging

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		···						
Part No		PAR #:						
	Re	esolution:	Disposit	on:	QA: N/C Cld	osed:	Date: _	
NCR:		,	WORK ORI	DER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC	Initial		ion B Sign &	Verification		Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
	ii I							
				·				

Work Order ID 75052 *75052* Page 4 October-17-11 10:39:17 AM Item ID: D3290-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Window 17/10/2011 **Start Date: Start Qty: 12.00 Cust Item ID: Required Date: 27/10/2011** Req'd Qty: 12.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: ____ Stop Date:_ **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Oty Number Stamp 200 QC21- Final Inspection - Work Order Release 0.00 *200*

0.00

Memo

Quality Control

MF 11-11-04

W/O:			W	ORK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·		. 1
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								3	
Part No);	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	Res	olution:	Dispositio	n:	_ QA: N/C C	losed:	 	Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	₹)			
DATE	STEP	Description of NC	Initial		Section B Verifica			Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector
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Picklist Print

October-17-11 10:39:21 AM

Work Order ID: 75052

75052

Parent Item:

D3290-3

D3290-3

Parent Item Name: Window

Start Date: 17/10/2011

Required Date: 27/10/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A04.08.18New issueKJ/RF

IPP B06.05.09Ecn 798 EC IPP Rev.

C Removed QC8 Step 160 11/04/11 DL

IPP 07.05.29. Thermoform in-house DL

IPP D 07.09.28 rev C dwg EC verified by: DD 07.11.28 Add --Hand finish deburring DL IPP

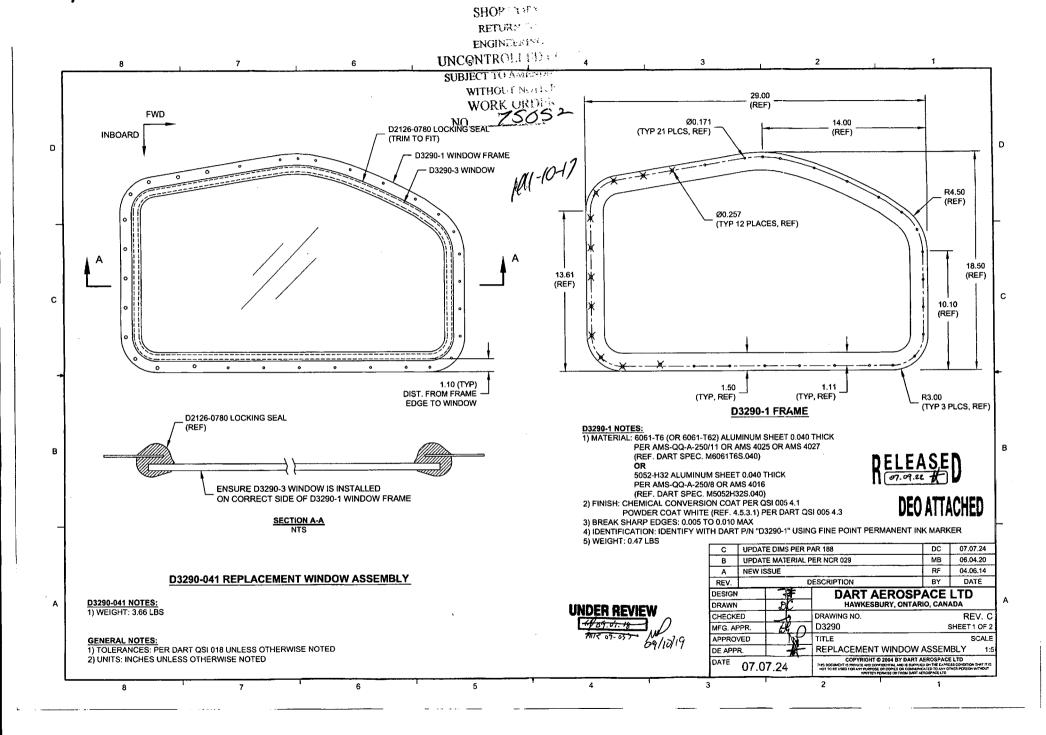
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	59.2434	3	37.89474	ļ		
MACRI IC 1/8" Polycast II Sheet	CS 125	•							**	BI	1-11-1		
•				Location		Loc (<u>Oty</u>	Loc Code				(i)	\
				MAT		55.9	9967					(14)
					117431	55.5	9967		U	7431	X 19=3	36	,
				MAT018		0.2	2467						
					117324	0.3	2467		_				
,				MAT019			3					2	
				•	115338		3			14338			
				1	117340				Į	17340	X (=	3	

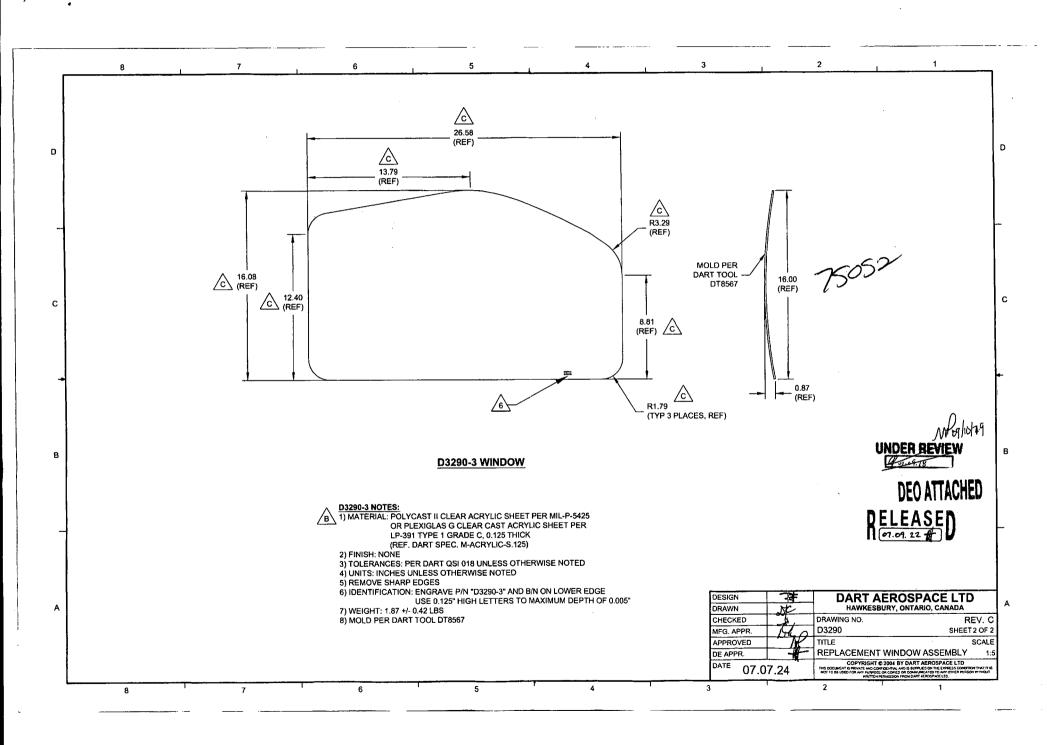
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,		-		
Part No	:	PAR #:	Fault Cate	norv:	NCR: Y	es No	n DOA		Date:	
		solution:								
NCR:				ER NON-CONFORMA						-
DATE	STEP	Description of NC		on B		Verifica	ation	Approval	Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Sectio		Chief Eng	QC Inspector
							•		·	
			· 1					i		

DART AEROSPACE LTD	Work Order:	75052
Description: Window	Part Number:	D3290-3
Inspection Dwg: D3290 Rev: C		Page 1 of 1

•	FIR	ST ARTICLE II	NSPECTI	ON CHE	ECKLIST		
		X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
26.58	+/-0.030	87.SC	1		T Rul		
16.08	+/-0.030	16.09)	2		7		
13.79	+/-0.030	13.79	φ		7		
12.40	+/-0.030	12.40			7		
8.81	+/-0.030	18.8			h		
					•		
1,000							
			ļ				
Measured by:	限	Audited by:	N/N		Prototype Ap	proval:	N/A
Date:	11-11-1	Date:	11/11/	0/		Date:	N/A
Rev Date A 08.01.16	Change New Issue				Revi	ised by C/DD	Approved

H:\FORMS\Quality Assurance\approved QA\FAI revD





DRAWING NO	O. TITLE	RE\	. C DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D3290	REPLACE	EMENT WINDOW AŞSEMI	ENGINEERING ORDER	D3290-C-1	SHEET 1 OF 1	NTS
DRAWN	P	CHECKED	MFG. APPR.	APPROVED A	DE APPR.	
DATE	09.09.18	DATE 09.09.18	DATE 69.09.18	DATE 09/09/21	DATE 09/09/2	2-1

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK (REPLACE)

PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027

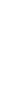
(REF. DART-SPEC. M6061T6S.040)- REF. DART SPEC. M6061T6S.063 (REPLACE)

OR

5052-H32 ALUMINUM SHEET 0.040 THICK (REPLACE)

PER AMS-QQ-A-250/8 OR AMS 4016

(REF. DART SPEC. M5052H32S.040) REF. DART SPEC. M5052H32S.063 (REPLACE)



2009 -10- 0 9

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